

Date: Thursday, 5/4/2006 1:09:31 PM
 User: Kim Johnston

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 27019
 Estimate Number : 12312
 P.O. Number : *NIA*
 This Issue : 5/4/2006 S.O. No. : *NIA*
 Prsht Rev. : NC
 First Issue : *NIA* Type : PURCHASED PARTS
 Previous Run : 26119
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 06-05-05
 Comment : Est Rev:A New Issue 06-03-02 JLM

Drawing Name : VERTICAL TUBE
 Part Number : D34735
 Drawing Number : D3473 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : *NIA*
 Due Date : 5/28/2006

Qty:

[Signature] 4
 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.1616 sf(s)/Unit Total : 0.6464 sf(s)

304/316 0.018 SHEET

Batch: *M4920910K*

made by Rand
17100817 (24)

FF 06-05-17

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

Cut as per Dwg D3473

Dwg Rev: *A*

Prog Rev: _____

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 *QC8* SECOND CHECK

cc5



Comment: SECOND CHECK

SR 06/05/12

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

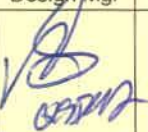



1-Deburr if necessary.


2-Roll & Bead as per Dwg D3473

3-Spot weld as per Dwg D3473

SR 06/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/10/02	1	2 piece were out of Tolerance		Scrap + destroy	SRB 06/10/02			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/10/04

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/4/2006 1:09:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUBE

Job Number: 27019

Part Number: D34735

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/9

WELD INSPECTION



Jul 10 03 (2)



Comment: WELD INSPECTION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

S442

GA

TOOK

1

SB 06/04/03

LB PU

1

06/10/03

8.0

DC

DOCUMENT CONTROL



(4)

Comment: DOCUMENT CONTROL

Inspection Level 21

Doc 10/04

Job Completion



C. Loe 10/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

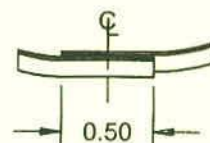
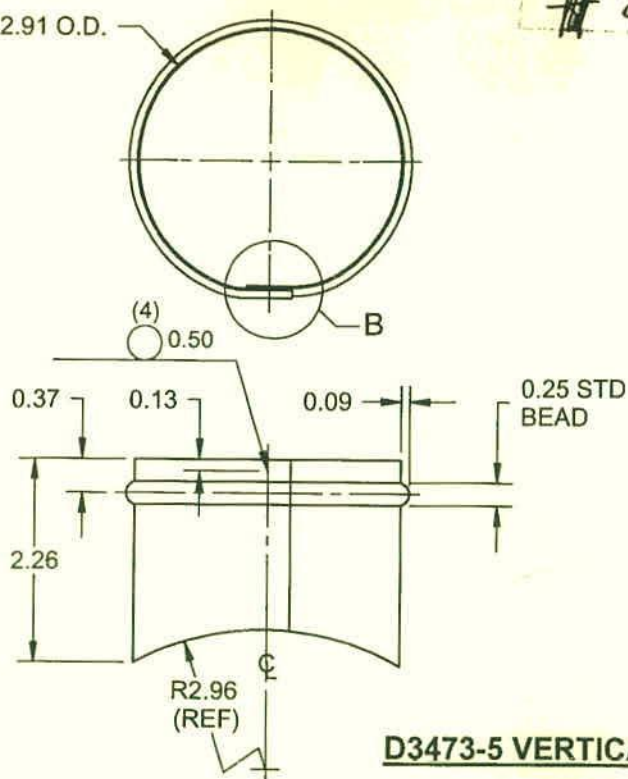
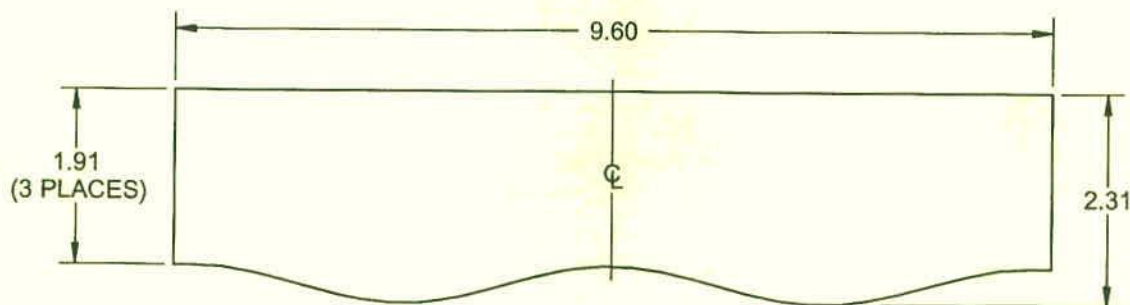
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3473	REV. A SHEET 5 OF 7
DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:2

Ø 2.91 O.D.

**DETAIL B**
SCALE 1:1**D3473-5 VERTICAL TUBE****D3473-5F VERTICAL TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27019

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NO. 17

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Sylvie Boucher
Joint Welding Procedure Spot weld
Part number and Job number D3473-5 B22019

TEST WELDS REQUIRED

BASE METAL S.S. WELDING PROCESS Spotweld
Penetration Complete ☒ Partial ☐ Single Weld ☐ Double Weld ☐
Current AC ☐ DC ☒ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/> <u>N/A</u>

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐ N/A

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06-10-03 Qualifier Jason Murdoch

